

Marathon Plus™ - Engineered for the Long Run

# Marathon Plus™ Fully Guided Tooling System

**New!**



[mate.com/marathonplus](http://mate.com/marathonplus)

**Part Number 2008**

***Trusted | Quality | Service | Solutions***

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# Marathon Plus™ Tooling System

All the benefits of Marathon® ....

.....plus external length adjustment!

## New Marathon Plus™ - all the benefits of Marathon® ...

- Fully guided longer lasting M2 punches for exceptional edge quality.
- Spring loaded stripper holds the sheet flatter.
- Includes 8 angle settings for maximum flexibility.
- Contained forces to reduce turret wear.

## ...Plus external punch length adjustment!

### Marathon Plus™ Punch Holders

- Fully hardened and ground for maximum precision and long life.
- Full length guiding in three positions (top, middle and punch tip) for perfect alignment and stability.
- Spring loaded stripping for flatter sheets and improved hole accuracy. Single draw bolt lock for positive punch retention.
- Self-locking stripper plate retention (no wrenches required).
- Self-releasing “pop-up” stripper for fast, easy tool change.
- Built-in lubrication vents for smooth, long life operation.
- Full station capacity.

## Plus external length adjustment for precise tool length setting in 0.005(0.12) increments without disassembly or additional tools.

### Marathon® Punches

- M2 High Speed Steel.
- Lasts longer between regrinds.
- Enables closer hole spacing.
- Back taper reduces galling.
- Improves piece part quality.
- Ideal for nibbling.

### Marathon® Stripper

- Guided lateral punch support.
- Quick tool change.
- Improve piece part quality.
- Extended tool life.

### SLUG FREE® Dies:

- High wear resistance.
- Eliminate slug pulling.
- Improved edge quality.
- Exceptional die strength.

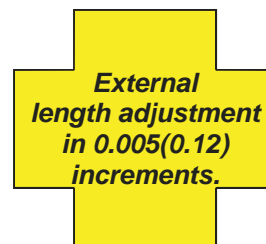
### Replacement Tang Kit:

- Retrofit existing inventory.
- Reduce set-up times.

### AVAILABLE FOR

- Vectrum
- Motorum
- Magnum 5000

### PUNCH PRESSES



# Marathon Plus™ Tooling System

## Order Guide

Station	Upper Turret Bore Diameter	Maximum Diagonal	Vectrum	Motorum	Magnum 5000
XB round only	1.692(42.98)	0.050(12.70)	MATE01159	MATE01159	
B Inner Track	2.250(57.15)	1.000(25.40)	MATE01141	MATE01141	MATE01144
B	2.250(57.15)	1.000(25.40)	MATE01141	MATE01141	MATE01141
C	3.125(79.38)	1.500(38.10)	MATE01090	MATE01090	MATE01090
C	3.375(85.73)	2.000(50.80)	MATE01132	MATE01132	MATE01132
D	3.125(79.38)	1.500(38.10)	MATE01090	MATE01090	MATE01090
D	3.375(85.73)	2.000(50.80)	MATE01132	MATE01132	MATE01132
D Varistation	4.172(105.97)	2.000(50.80)	MATE01091	MATE01091	
D Auto-Index	3.375(85.73)	2.000(50.80)			MATE01145
E	4.562(115.87)	2.500(63.50)	MATE01136	MATE01136	MATE01136
F	4.562(115.87)	3.000(76.20)	MATE01136	MATE01136	MATE01136
E	5.938(150.83)	2.500(63.50)		MATE01137	
F	5.938(150.83)	3.000(76.20)		MATE01137	
F Varistation	4.172(105.97)	3.000(76.20)	MATE01131	MATE01131	
G	5.938(150.83)	3.500(88.90)	MATE01154	MATE01154	MATE01154
H	5.938(150.83)	4.125(104.78)	MATE01154	MATE01154	MATE01154
J	5.938(150.83)	4.750(120.65)	MATE01299	MATE01299	MATE01299
G	6.750(171.45)	3.500(88.90)			MATE01155
H	6.750(171.45)	4.125(104.78)			MATE01155
J	6.750(171.45)	4.750(120.65)			MATE01300

### Marathon Plus™ Replacement Tang Kit

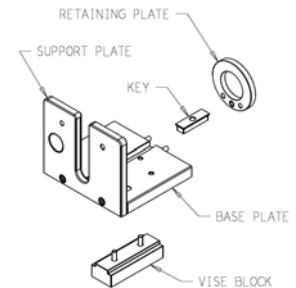
Replacement tang kits allow existing Marathon® punch holders\* to be converted to use the new Marathon Plus external length adjustment mechanism.

Marathon Plus™ Punch Holder	Tang Kit
MATE01144	MATE01142
MATE01141	MATE01142
MATE01159	MATE01158
MATE01132	MATE01088
MATE01091	MATE01088
MATE01090	MATE01088
MATE01145	MATE01088
MATE01137	MATE01135
MATE01136	MATE01135
MATE01131	MATE01095
MATE01154	MATE01149
MATE01155	MATE01149
MATE01300	MATE01301
MATE01299	MATE01301

### Marathon Plus™ Accessories

The Marathon Plus Torque Stand is recommended when changing a punch and stripper. It allows the punch holder to be held securely during punch installation. This convenient torque stand can be machine or vise mounted.

#### Marathon Plus Torque Stand



MATE01293

#### Maintenance Fixture



FXAR0000

Marathon Plus punch holder assemblies require very little routine maintenance. However, every few months the punch-receiver/tang should be disassembled from the punch holder to be inspected and cleaned. Disassembly is accomplished using this maintenance fixture.



**MATE**<sup>®</sup>  
**M**  
**PRECISION  
TOOLING**

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